

BLUE

Dart Aerospace Ltd.

23

Date:
User:Wednesday, 5/16/2007 8:14:43 AM
Kim Johnston

Process Sheet

Split-2

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32384
 Estimate Number : 10836
 P.O. Number : *N/A*
 This Issue : 5/16/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 31252
 Written By : *[Signature]*
 Checked & Approved By : *[Signature] 07.05.16*
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW
 Part Number : D29391 *up*
 Drawing Number : D2939 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 6/6/2007 Qty: 16 *12* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: *1331386*

SA 07.06.26 12

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly. *J.F.*

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

SA 07.06.26 12

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 07.06.26 12

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 07.06.26 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/07/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:14:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER
REVIEW

Job Number: 32384

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BL 07/06/29 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/06/29 (12)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

N/A

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stock unpacked

07/06/29 (12) UP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/11 (12)

Job Completion



07/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 32384
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.127	0.127	0.127	0.126		
B	0.100	0.140		.127	0.127	0.127	0.128		
C	0.100	0.140		.128	0.130	0.125	0.128		
D	0.210	0.230		.223	0.222	0.222	0.222		
E	1.245	1.255		1.250	1.249	1.249	1.248		
F	1.245	1.255		1.250	1.249	1.250	1.249		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.516		
I	1.572	1.582		1.577	1.577	1.576	1.575		
J	2.495	2.505		2.501	2.500	2.500	2.500		
K	0.257	0.262		.258	0.259	0.258	0.258		
L	0.312	0.317		.313	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.118	0.119	0.118	0.120		
O	0.540	0.560		.549	0.548	0.549	0.547		
P	0.490	0.510		.498	0.504	0.504	0.504		
Q	3.715	3.725		3.720	3.717	3.718	3.718		
R	2.720	2.760		2.745	2.740	2.743	2.743		
S	0.240	0.270		.256	0.252	0.252	0.253		
T	0.100	0.180		.137	0.136	0.135	0.138		
U	1.625	1.635		1.630	1.628	1.628	1.628		
V	1.362	1.372		1.364	1.367	1.367	1.367		
W	0.316	0.321		.318	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.261	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.574	1.573	1.573	1.572		
Z	0.178	0.198		.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SA/9nd
Date: 07.06.27

Audited by: BG
Date: 07.06.29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32384
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.112	0.126	0.125		
B	0.100	0.140		0.126	0.114	0.126	0.126		
C	0.100	0.140		0.124	0.122	0.123	0.122		
D	0.210	0.230		0.223	0.223	0.224	0.225		
E	1.245	1.255		1.241	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.516	0.510	0.510	0.510		
I	1.572	1.582		1.575	1.576	1.576	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.120	0.120	0.121	0.122		
O	0.540	0.560		0.550	0.549	0.550	0.549		
P	0.490	0.510		0.504	0.504	0.505	0.505		
Q	3.715	3.725		3.717	3.717	3.717	3.718		
R	2.720	2.760		2.743	2.743	2.743	2.743		
S	0.240	0.270		0.254	0.254	0.255	0.253		
T	0.100	0.180		0.146	0.138	0.135	0.138		
U	1.625	1.635		1.628	1.628	1.628	1.629		
V	1.362	1.372		1.365	1.367	1.367	1.367		
W	0.316	0.321		0.326	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.263	1.263		
Y	1.565	1.585	DT8695 A/B	1.573	1.574	1.572	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>gmb</i>
Date:	07/06/28

Audited by:	<i>SG</i>
Date:	07.06.29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	32384
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

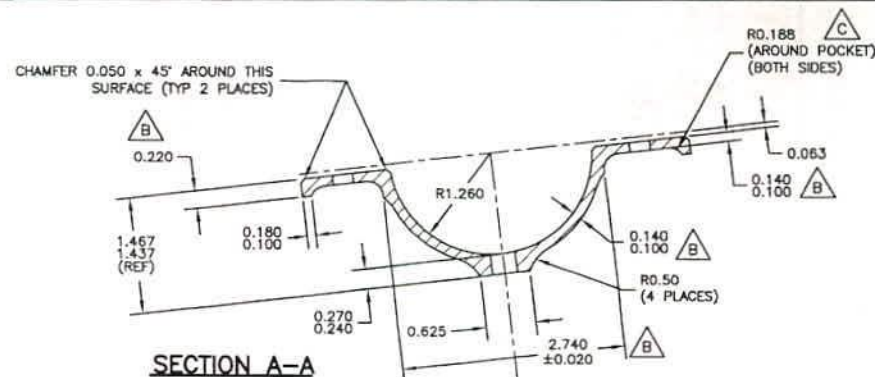
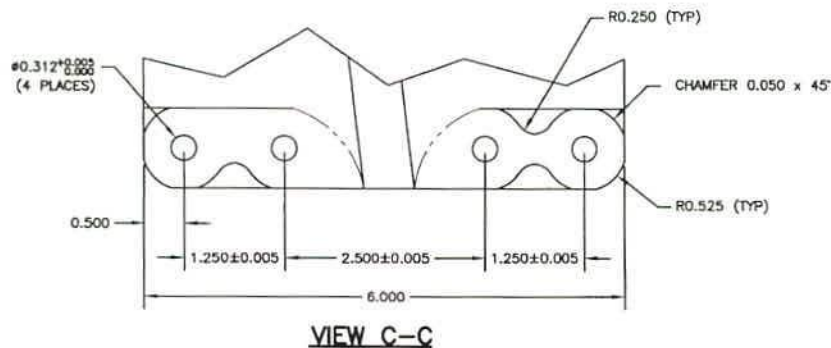
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.125	0.128	0.126	0.128		
B	0.100	0.140		0.126	0.127	0.125	0.127		
C	0.100	0.140		0.123	0.125	0.125	0.125		
D	0.210	0.230		0.224	0.229	0.223	0.223		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.238	0.239	0.239		
N	0.100	0.140		0.121	0.119	0.120	0.118		
O	0.540	0.560		0.549	0.550	0.549	0.550		
P	0.490	0.510		0.504	0.504	0.503	0.503		
Q	3.715	3.725		3.717	3.717	3.718	3.718		
R	2.720	2.760		2.743	2.743	2.740	2.743		
S	0.240	0.270		0.252	0.253	0.253	0.255		
T	0.100	0.180		0.138	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.262	1.259	1.260	1.259		
Y	1.565	1.585	DT8695 A/B	1.572	1.572	1.572	1.572		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	07/06/28

Audited by:	<i>[Signature]</i>
Date:	07/06/29

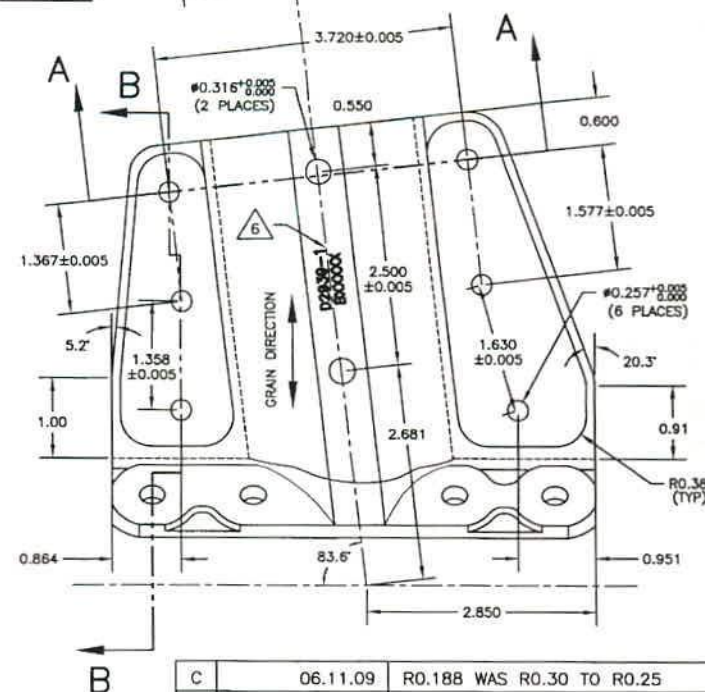
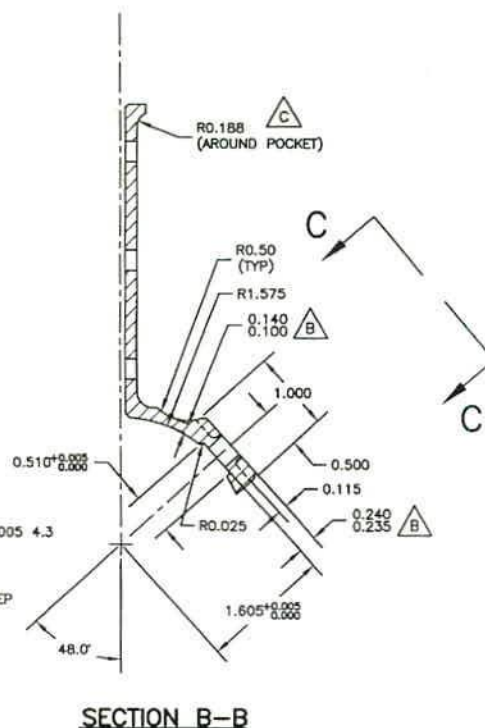
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



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C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	TITLE	SADDLE INSIDE
06.11.09		SCALE 2:3

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22384